

**Work Order ID 67001**

Page 1

Thursday, March 03, 2011 10:46:00 AM

Item ID: D2857-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Bracket

Start Date: 3/3/2011 Start Qty: 24.00



Cust Item ID:

Required Date: 3/7/2011 Req'd Qty: 24.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

11-03-3

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D2857

Rev C

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks 4.425"

SL 11/04/02

24

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FA940  
FOLIO REV: AA  
DWG REV: C  
2-Deburr any rough edges

SL 11/05/02

24

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL 11/05/02

24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 67001**

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Page 2

Item ID: D2857-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Bracket

Start Date: 3/3/2011 Start Qty: 24.00



Cust Item ID:

Required Date: 3/7/2011 Req'd Qty: 24.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

24 11-5-3

24

φ

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

24

φ

24 11/05/03

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

24.

BR 11-5-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Work Order ID 67001

Thursday, March 03, 2011 10:46:00 AM



Page 3

Item ID: D2857-2	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Hinge Bracket					
Start Date: 3/3/2011	Start Qty: 24.00		Cust Item ID:		
Required Date: 3/7/2011	Req'd Qty: 24.00		Customer:		
Reference:					

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  Powdercoat Powder Coating M116964	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum  Memo START TIME: 8:40 FINISH TIME: 9:10 OVEN TEMPERATURE:	0.00 0.00				24	0	M. L. 11/05/09	
170  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00				24	0	M. L. 11/05/09	
180  Packaging Packaging	Identify as per dwg & Stock Location: 24  Memo	0.00 0.00				11/5/9	24	(24)	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_






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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



**NOTE:** Date & initial all entries


**Work Order ID 67001**

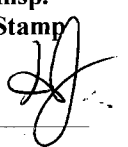
Page 4

Thursday, March 03, 2011 10:46:00 AM

Item ID: D2857-2      Accept            Setup      Start        
Revision ID:      Stop        
Item Name: Hinge Bracket  
Start Date: 3/3/2011      Start Qty: 24.00            Cust Item ID:  
Required Date: 3/7/2011      Req'd Qty: 24.00            Customer:  
Reference:

Approvals:      Process Plan: \_\_\_\_\_      Date: \_\_\_\_\_      Tooling: \_\_\_\_\_      Date: \_\_\_\_\_      Run      Start        
QC: \_\_\_\_\_      Date: \_\_\_\_\_      SPC (Y/N): \_\_\_\_\_      Date: \_\_\_\_\_      Stop      

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

11/5/11   
ME  
11-05-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Thursday, March 03, 2011 10:46:07 AM

Page 1

Work Order ID: 67001

Parent Item: D2857-2

Parent Item Name: Hinge Bracket



Start Date: 3/3/2011

Required Date: 3/7/2011

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP - ☐ C 00.06.22 Removed P/O for powder coat ☐ EC ☐  
IPP D 06.03.30 ☐ Added level 8 EC ☐ IPP Rev:E 11.01.06 as  
per dwg revC DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6B2.000X01.25

Purchased

No

100

f

34.3055

0.37

9.347368

0



6061-T6 Bar 2.00 x 1.25



DL 11/04/21

## Location

## Loc Qty

## Loc Code

MAT

34.3055

114507 19

7.6555

114899

2.65

116623

24

- 7.6555  
- 1.75 - 100% enough

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	<i>67001</i>
<b>Description:</b> Hinge Bracket		<b>Part Number:</b>	D2857-2
<b>Inspection Dwg:</b> D2857 <b>Rev:</b> B		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	<i>4.300</i>	<i>✓</i>		<i>Vern JL-3</i>	
4.000	+/-0.010	<i>4.000</i>	<i>✓</i>		<i>H-G</i>	
0.340	+/-0.010	<i>0.340</i>	<i>✓</i>		<i>"</i>	
1.110	+/-0.005	<i>1.110</i>	<i>✓</i>		<i>"</i>	
1.790	+/-0.010	<i>1.791</i>	<i>✓</i>		<i>"</i>	
1.320	+/-0.005	<i>1.320</i>	<i>✓</i>		<i>"</i>	
2.000	+/-0.010	<i>2.001</i>	<i>✓</i>		<i>"</i>	
0.340	+/-0.010	<i>0.340</i>	<i>✓</i>		<i>"</i>	
0.447	+/-0.010	<i>0.445</i>	<i>✓</i>		<i>"</i>	
Ø0.171	+0.005/-0.000	<i>0.173</i>	<i>✓</i>		<i>"</i>	
0.147	+/-0.010	<i>0.148</i>	<i>✓</i>		<i>"</i>	
0.376	+/-0.010	<i>0.379</i>	<i>✓</i>		<i>"</i>	
0.126	+/-0.010	<i>0.126</i>	<i>✓</i>		<i>"</i>	
0.063	+/-0.010	<i>0.063</i>	<i>✓</i>		<i>"</i>	
Ø0.166	+0.005/-0.000	<i>0.168</i>	<i>✓</i>		<i>"</i>	
0.911	+/-0.010	<i>0.912</i>	<i>✓</i>		<i>H-G</i>	
0.600	+/-0.010	<i>0.601</i>	<i>✓</i>		<i>"</i>	
0.125	+/-0.010	<i>0.126</i>	<i>✓</i>		<i>"</i>	
0.150	+/-0.010	<i>0.149</i>	<i>✓</i>		<i>"</i>	

<b>Measured by:</b> <i>JK</i>	<b>Audited by:</b> <i>RP</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b> <i>11/05/02</i>	<b>Date:</b> <i>11.5.3</i>	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	
B	07.04.20	Dimensions update per Dwg Rev B	KJ/JLM <i>AK</i>	<i>JK</i>

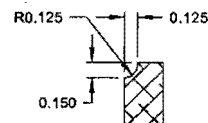
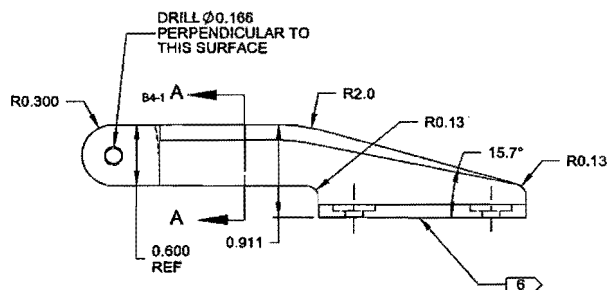
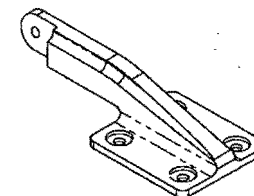
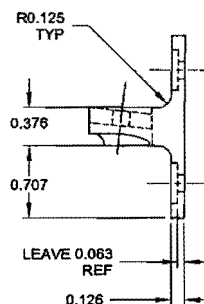
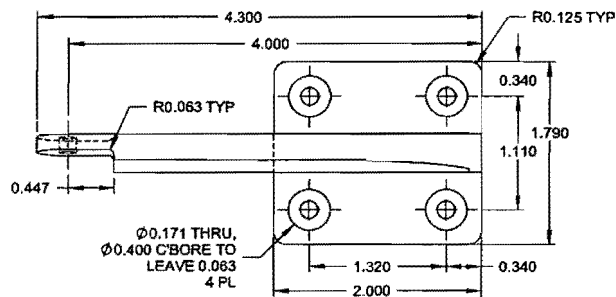
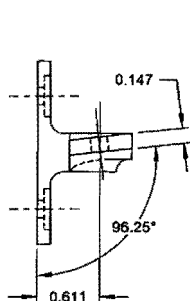
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



SECTION A-A

D2857-1 HINGE BRACKET

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 67001  
R/11-03-3

RELEASED  
2010-11-26

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-200/8 OR QQ-A-225/8 OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N "D2857-1" PER DART QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 0.11 lbs

C	REFORMAT DWG. IDENTIFICATION BY MARKER WAS ENGRAVING (A8-1), REF PAR 10-040	CP	10.09.13
B	ADD THICKNESS, REDRAW W/ SOLIDWORKS	LE	06.08.28
A	NEW ISSUE	KE	98.12.14
REV.	DESCRIPTION	BY	DATE
DESIGN	KE		
DRAWN	GP		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.09.13		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D2857	REV. C
TITLE HINGE BRACKET	SCALE NTS
COPYRIGHT © 1998 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR THE REPRODUCTION OF ANY PART THEREOF WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

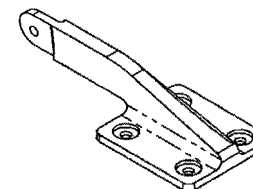
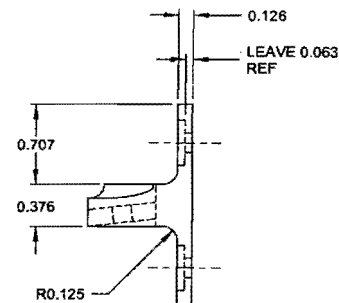
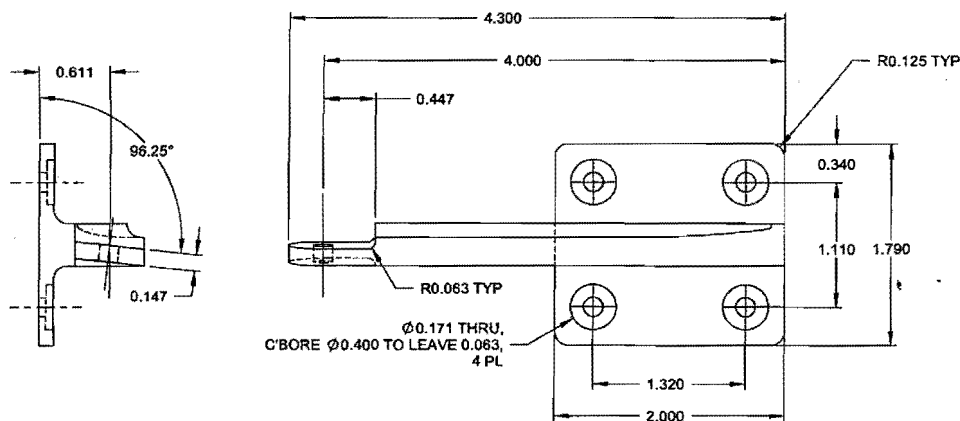
W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

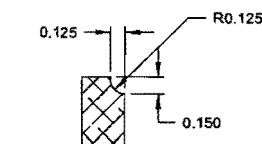
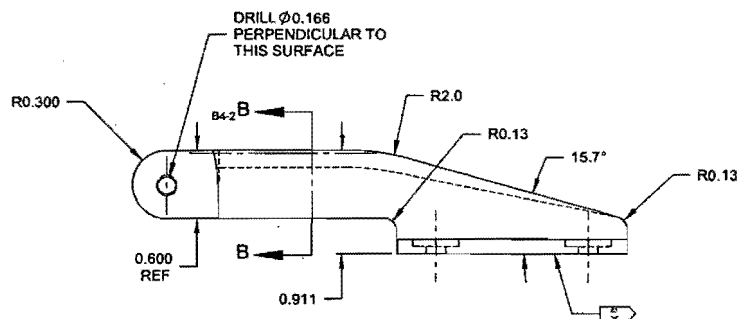
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**NOTE:** Date & initial all entries



*W64-1001*



B7-2 **SECTION B-B**

**D2857-2 HINGE BRACKET**

**RELEASED**  
2010-11-26

**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-200/8 OR QQ-A-225/8 OR ASTM B211 OR ASTM B221  
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- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N "D2857-2" PER DART QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 0.11 lbs

DESIGN	KE	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>gt</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D2857	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	HINGE BRACKET	NTS
DATE	10.09.13	<small>COPYRIGHT © 1998 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESSED UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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